

Work Order ID 62731

Wednesday, October 06, 2010 2:38:12 PM



Page 1

Item ID: D3947-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel, Lower LH Post

Start Date: 10/6/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: 1/

Date: 10-10-05

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3947

A

100

0.00



HAND FINISHING THERMOFORMING

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Cut Blanks to fit frame size

1 BB 10/10/05

105

0.00



Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QS1022 POLYCARBONATE

Temp: 240°F

Time IN: 4:30 10/10/05

Time OUT: 7:00 10/10/06

BB
10/10/05

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 62731

Wednesday, October 06, 2010 2:38:12 PM

Page 2

Item ID: D3947-3

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Setup Start

Revision ID:

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Item Name: Panel, Lower LH Post

Start Date: 10/6/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 1.00




Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 110  Thermoform Thermoforming Machine | THERMOFORMING MACHINE Memo 1-Machine Set-up 2-Pre-heat tool 3-Thermoform as per Dwg. D3947-3 and Folio FTA 046 using tool DT9484 Dwg. Rev. <u>A</u> Folio Rev. <u>B</u> | 0.00 0.00 | | | | | | | |
| 120  QC Quality Control | QC2- Inspect parts off machine FAI/FAIB Memo Visually inspect for proper formation of each part | 0.00 0.00 | | | | | | | |
| 130  QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | | | | | | |

BB 10/10/06
(X1) BB 10/10/06

(X1) BB 10/10/06

(X1) 10/10/06

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 62731

Wednesday, October 06, 2010 2:38:12 PM

Page 3

Item ID: D3947-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Panel, Lower LH Post

Start Date: 10/6/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 1.00

Customer:







Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|--|
| 140  Thermoform | HAND FINISHING THERMOFORMING | 0.00 | | | | | | | |
| Thermoforming Machine | Memo Trim to Finished Dimensions as per dwg D3946-1 | 0.00 | | | | | | |  (KI) 10/10/07 |
| 150  QC | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | |
| Quality Control | Memo Check dimensions to ensure conformity to drawing tolerances. | 0.00 | | | | | | |  (KI) 10/10/07 |
| 160  QC | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| Quality Control | Memo | 0.00 | | | | | | |  (KI) 3 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 62731

Wednesday, October 06, 2010 2:38:12 PM

Page 4

Item ID: D3947-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Panel, Lower LH Post

Start Date: 10/6/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 1.00

Customer:



Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|--|
| 170  Packaging | Identify as per dwg & Stock Location: _____ Memo <i>PPP 61587</i> | 0.00 0.00 | | | | | | | <i>10/10/13</i> <i>(1)</i> |
| 180  QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | <i>10/10/13</i> <i>MF</i> <i>10-10-13</i> |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 06, 2010 2:38:16 PM

Page 1

Work Order ID: 62731



Parent Item: D3947-3



Parent Item Name: Panel, Lower LH Post

Start Date: 10/6/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

Ipp Rev B

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MLEXS.093-F6006-07 | | Purchased | No | | | 100 | sf | 1,862.321 | 3.444 | 3.625263 | | | |
| | | | | | | | | | | | | | |
| GE PLASTICS LEXAN SHEET | | | | | | | | | | | | | |

Location

therm

Loc Qty

1862.321

Loc Code

107574

6.46

111973

23.915

112176

101.2267

114459

1730.7193

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(X1)

BB 10/06.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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|--|-----------------------------|
| DART AEROSPACE LTD | Work Order: 62731 |
| Description: Panel, Lower LH | Part Number: D3947-3 |
| Inspection Dwg: D3947 Rev: A | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

| Description | Accept | Reject | Method of Inspection | Comments |
|---|--------|--------|----------------------|----------|
| Inside Radii less than " | ✓ | | | |
| Shape Definition | ✓ | | | |
| Texture Retention | ✓ | | | |
| Material imperfections such as bumps, cracks, voids, scratching | ✓ | | | |
| | | | | |
| | | | | |
| | | | | |

Measured by: Oh **Date:** 10/10/06

TRIMMING SECTION

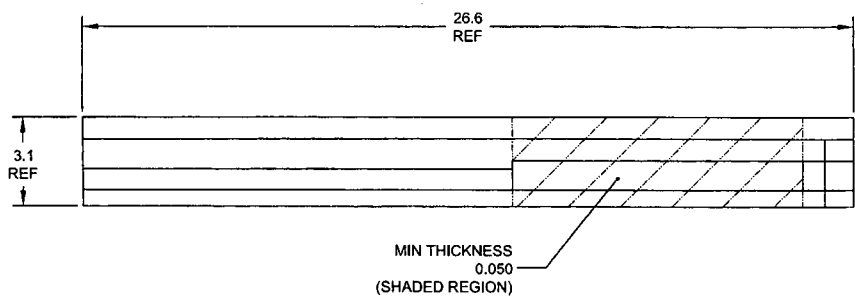
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 0.5 | Min | 0.55" | ✓ | | | |
| 1.8 | Min | 1.94" | ✓ | | | |
| 0.050 | Min | 0.051" | ✓ | | | |
| 0.065 | Min | 0.071" | ✓ | | | |
| 22.5 | REF | 23" | ✓ | | | |
| 10.8 | REF | 10.875" | ✓ | | | |
| | | | | | | |
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Measured by: Oh **Date:** 10/10/07
Audited by: BB **Date:** 10/10/07
Prototype Approval: N/A **Date:** N/A

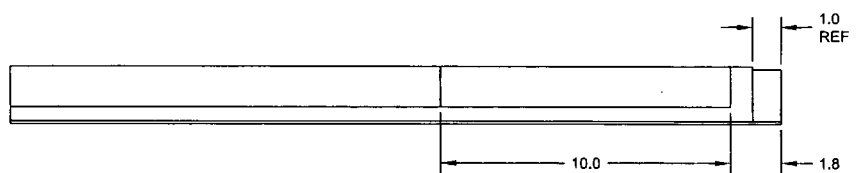
| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 09.09.15 | New Issue | KJ | <u>M</u> |

8 7 6 5 4 3 2 1

D



C



B

D3947-1 PANEL, LH

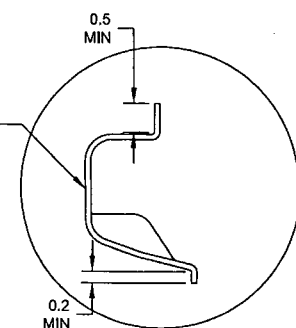
A

- NOTES:**
- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3947-1" AND B/N USING VIBRATING STYLUS
 - 7) WEIGHT: 0.42 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9483 PER DART QSI 022. TRIM PER MOLD
 - 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.070" ELSEWHERE

8 7 6 5 4 3 2 1



DETAIL A C2-1



DETAIL A C3-1
SCALE 2X

SHOP COPY
RETURNED
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO APPROVAL
WITH ENGINEERING
WORK ORDER
NO. *12731*
B/10-10-04

RELEASED
01/05/14

| A NEW ISSUE | | PH | 09.05.20 |
|-------------|-------------|--|--------------|
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | <i>PH</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | <i>PH</i> | | |
| CHECKED | <i>PH</i> | DRAWING NO. | REV. A |
| MFG. APPR. | <i>PH</i> | D3947 | SHEET 1 OF 4 |
| APPROVED | <i>PH</i> | TITLE | SCALE |
| DE APPR. | <i>PH</i> | PANEL (AS 350/355) | NTS |
| DATE | 09.05.20 | COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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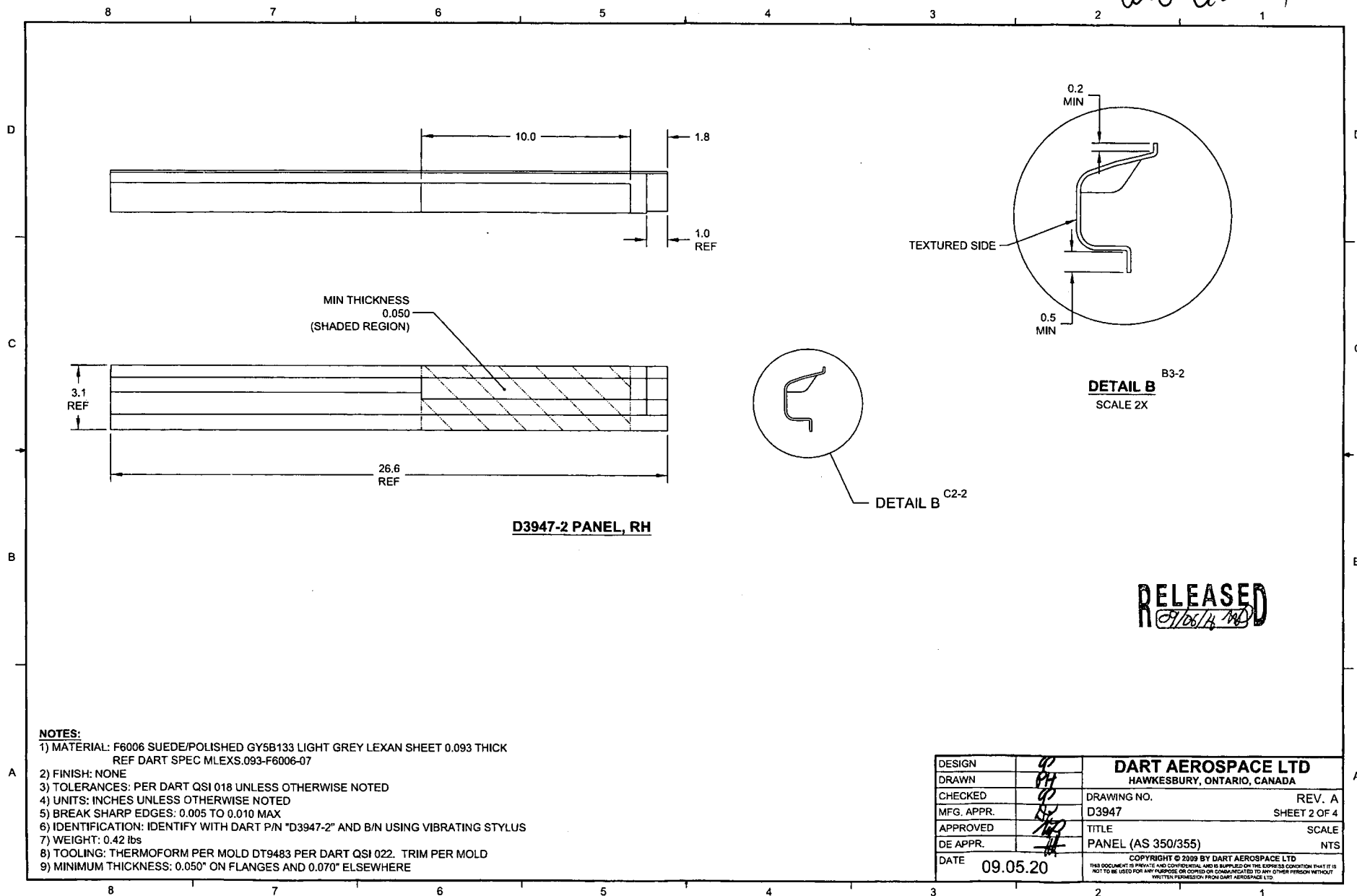
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

also 6273



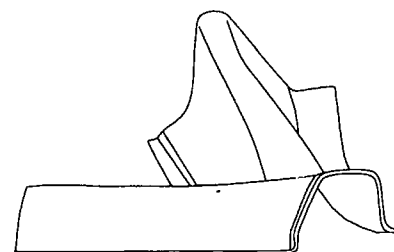
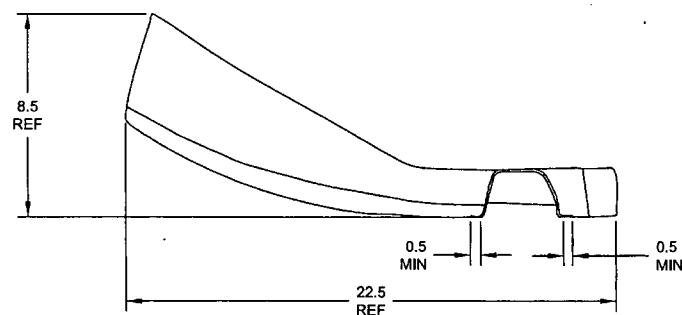
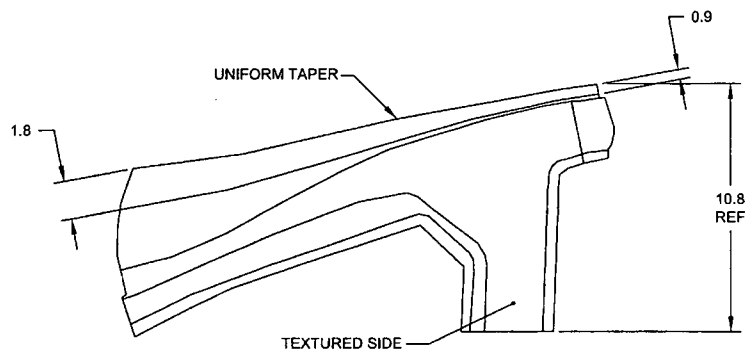
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| | | | | | | | | |

NOTE: Date & initial all entries



D3947-3 PANEL, LH

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3947-3" AND B/N USING VIBRATING STYLUS
- 7) WEIGHT: 0.55 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9484 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE

| | | |
|--|-----------|--|
| DESIGN | | DART AEROSPACE LTD |
| DRAWN | <i>SP</i> | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | <i>SP</i> | DRAWING NO. REV. A |
| MFG. APPR. | <i>SP</i> | D3947 SHEET 3 OF 4 |
| APPROVED | <i>SP</i> | TITLE SCALE |
| DE APPR. | <i>SP</i> | PANEL (AS 350/355) NTS |
| DATE | 09.05.20 | COPYRIGHT © 2008 BY DART AEROSPACE LTD |
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RELEASED
09/06/14

Wb62731

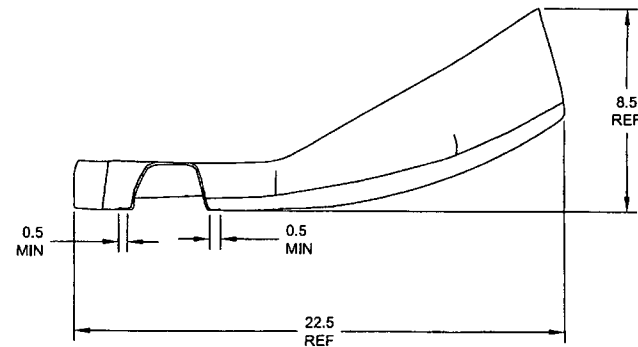
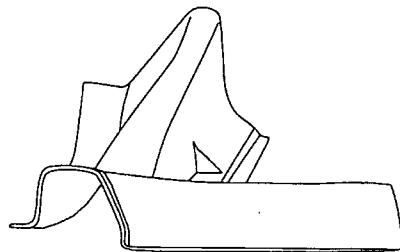
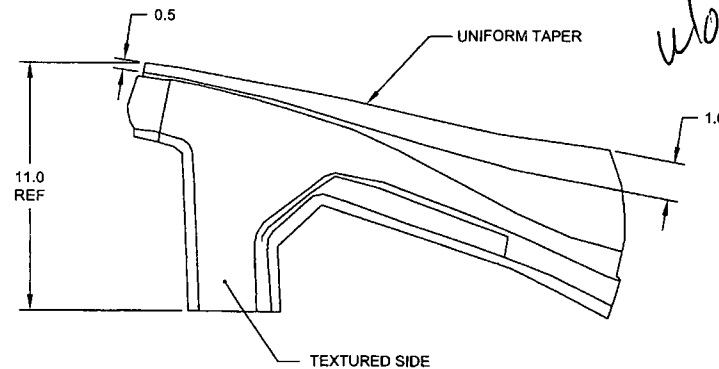
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NOTE: Date & initial all entries









D3947-4 PANEL, RH

RELEASED
09/05/20

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3947-4" AND B/N USING VIBRATING STYLUS
- 7) WEIGHT: 0.62 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9484 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE

| | | | |
|--|---|--|--------------|
| DESIGN |  | DART AEROSPACE LTD | |
| DRAWN |  | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. A |
| MFG. APPR. |  | D3947 | SHEET 4 OF 4 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | PANEL (AS 350/355) | NTS |
| DATE | 09.05.20 | COPYRIGHT © 2009 BY DART AEROSPACE LTD | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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